



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T102137-111
Job Sheet 176839



Part No: RB T102137-111

Job Qty: 2 ea

Part Name: Lifting Tool *stock.*



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Due Date: 5/21/18

Created By: Chantal Lavoie

Type: Stock

Description:

Ship Via:

DAS
10
9-89

REV. A.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		5/21/18	0.00	0.00	Purchasing		<i>11/8/18/18</i>
110	Packaging	2 pcs		5/21/18	0.00	0.00	Packaging2		<i>11/8/18/18</i>
120	QC	2 pcs		5/21/18	0.00	0.00	QC6		<i>EB</i>
130	Packaging	2 pcs		5/21/18	0.00	0.00	Packaging3		<i>DAS 21</i>
140	QC21-SA	2 Ea		5/21/18	0.00	0.00	QC21		<i>MAY 0 9 2018 GAO</i>

Part Op 100 - ISSUE P/O: *039773*
Descriptions: OF C IS REQUIRED

SUPPLIER: METEC MANUFACTURE, RB T102137-111 AS PER DWG

MAY 0 2 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T102137-111P	Lifting Tool	2 pcs (1 ea)	100-Purchasing	<i>2068559</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T102137-111P	2	1	0

Part Specifications

Specifications could not be found.

Plex 5/2/18 8:08 AM dart.lavoie.chantal



Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S068563



Lifting Tool

PART NO: RB T102137-111

Serial No/Batch: S068563

Revision:

Operation:

Change No:

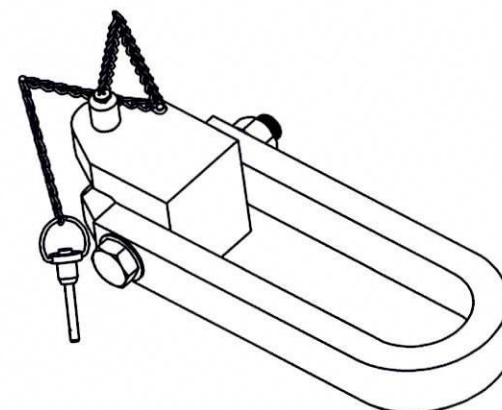
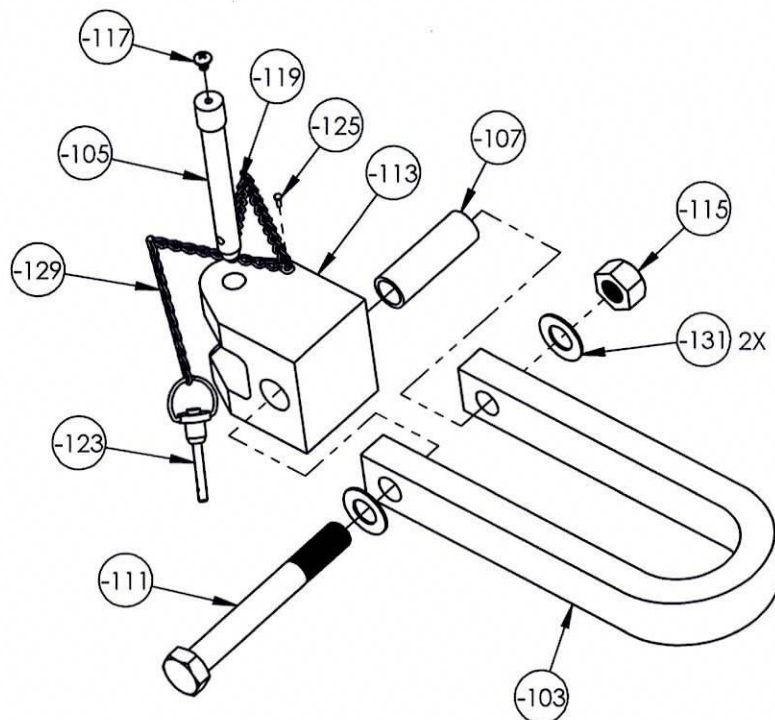
Packaging

Mfg Date: 05/04/18

Job No: 176839

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A	14-0208	DELETED NOTE 2 SHEET ONE. -103 CH'D ENGRAVE NOTE ONE SIDE TO READ ENGRAVE T/N, S/N, "MADE IN USA", THE OTHER SIDE TO READ ENGRAVE "CAPACITY 12000LBS" PROOF LOAD 24000LBS TO FIT.	11/4/2014	RJC	JAG



NOTES

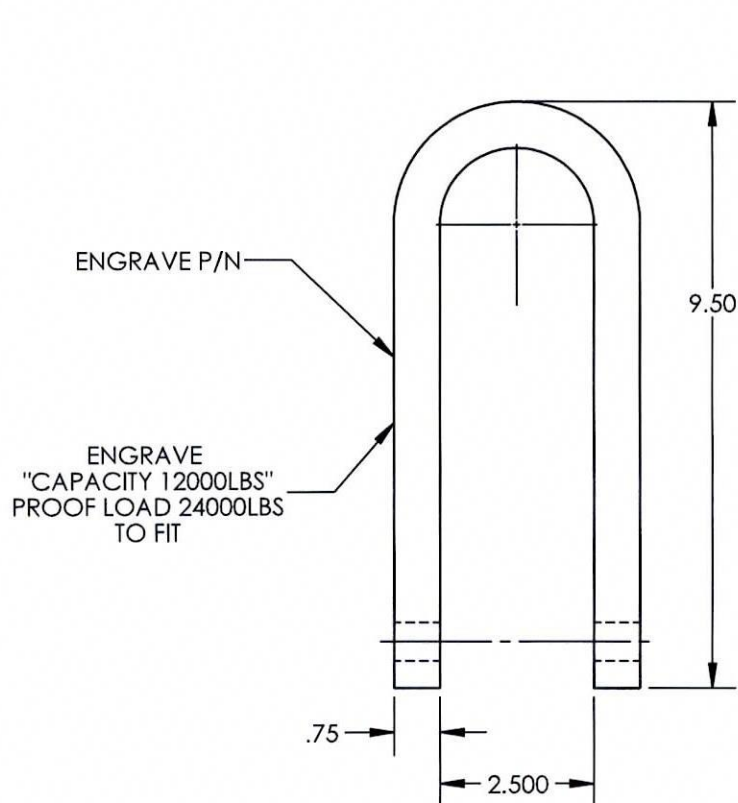
1. TORQUE -115 NUT TO 30-55 FT.LBS.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-103	1	STRAP	4140	1-1/4 X 4-1/8 X 9-5/8 (SAME AS RB T102140-103)	2
			-105	1	PIN	4140	Ø5/8 X 4-3/4	3
			-107	1	SLEEVE	4130	Ø7/8 X 2-5/8 (SAME AS RB T102140-107)	4
		B/O	-111	1	HEX HEAD CAP SCREW	Gr. 8 CAD PLATED	5/8-18 UNF X 5 (NAS6610-64)	1
			-113	1	CLEVIS	4140	2-1/2 X 3 X 3-5/8	5
		B/O	-115	1	FLANGE NUT	CAD PLATED STEEL	5/8-18 UNF (NAS1291-10)	1
		B/O	-117	1	PHILLIPS MACH. SCREW	PLATED STEEL	10-24 X 1/4 MCMaster-CARR #90272A238	1
		B/O	-119	1	CHAIN	BRASS	1/0 SIZE X 10" LONG (NAS1455B00-10)	1
		B/O	-123	1	BALL LOCK PIN	PLATED STEEL	Ø3/16 X 1" USABLE (NAS1333S6S10D)	1
		B/O	-125	1	DRIVE SCREW	PLATED STEEL	Ø.100 X 1/4 (MS21318-15)	1
		B/O	-129	1	CHAIN	BRASS	1/0 SIZE X 6" LONG (NAS1455B00-6)	1
		B/O	-131	2	FLAT WASHER	CAD PLATED STEEL	Ø5/8 ID (MS20002C10)	1

DART AEROSPACE	
TITLE LIFTING TOOL	
DWG NO. RB T102137-111	
REV A	
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: DUERFELDT APPROVED: <i>J Gilbert</i> HEAT TREAT FINISH SPEC USED ON MODEL BELL 429
SCALE 1:4	DATE 10/1/2014 SHEET 1 OF 6

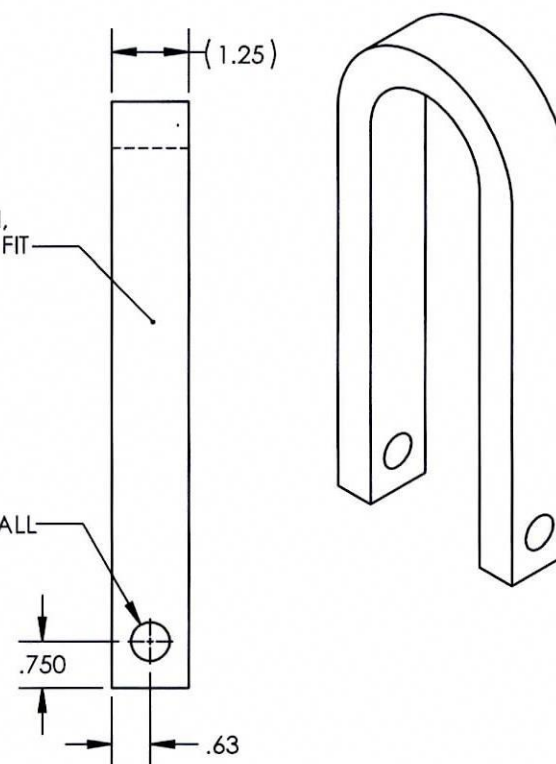
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REVISIONS					
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A	14-0208	-103 CH'D ENGRAVE NOTE ONE SIDE TO READ ENGRAVE T/N, S/N, "MADE IN USA", THE OTHER SIDE TO READ ENGRAVE "CAPACITY 12000LBS" PROOF LOAD 24000LBS TO FIT.	11/4/2014	RJC	JAG



ENGRAVE T/N, S/N, "MADE IN USA" TO FIT

Ø .6260 THRU ALL
Ø .6245



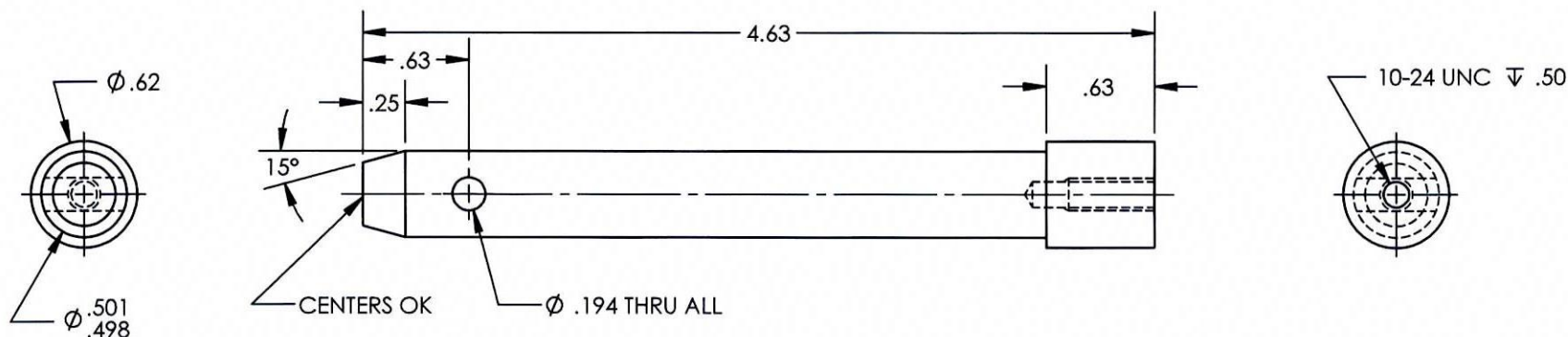
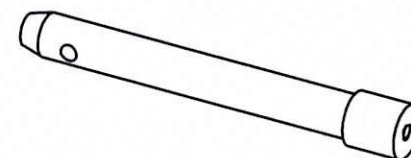
(-103)

STRAP

DART AEROSPACE	
TITLE LIFTING TOOL	
DWG NO. RB T102137-111-103	REV A
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J. Gilbert</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT RC 32-38
.XX ± .01 ANGLES ± 5°	TREAT CAD PLATE YELLOW
.X ± .1	FINISH QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 429
SCALE 1:3	DATE 10/1/2014 SHEET 2 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



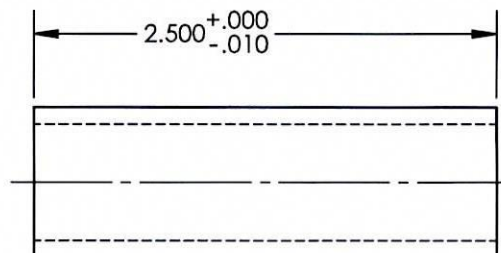
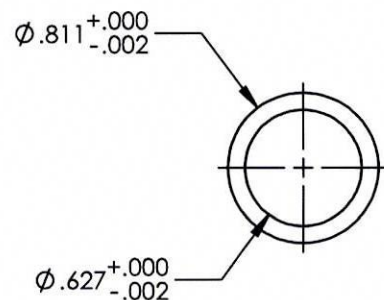
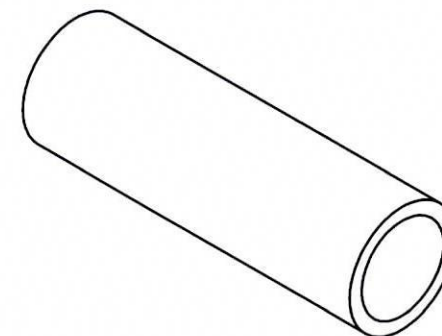
-105

PIN

DART AEROSPACE	
TITLE LIFTING TOOL	
DWG NO. RB T102137-111-105	REV A
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Gilbert</i>
.XXX $\pm$.005	HEAT TREAT RC 46-50
.XX $\pm$.01	FINISH CAD PLATE YELLOW
.X $\pm$.1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 429
SCALE 1:1	DATE 10/1/2014 SHEET 3 OF 6

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



NOTE:
SAME PART AS T102140-107

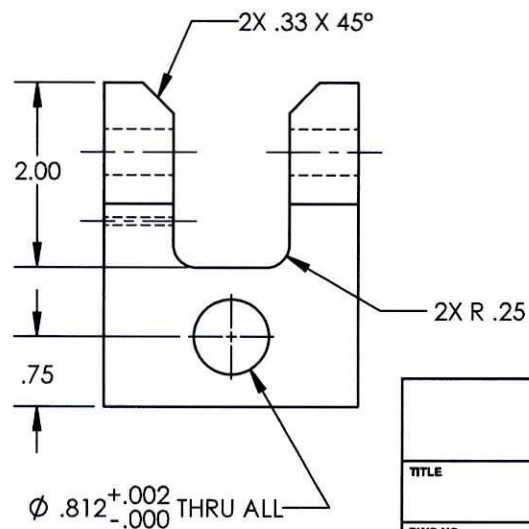
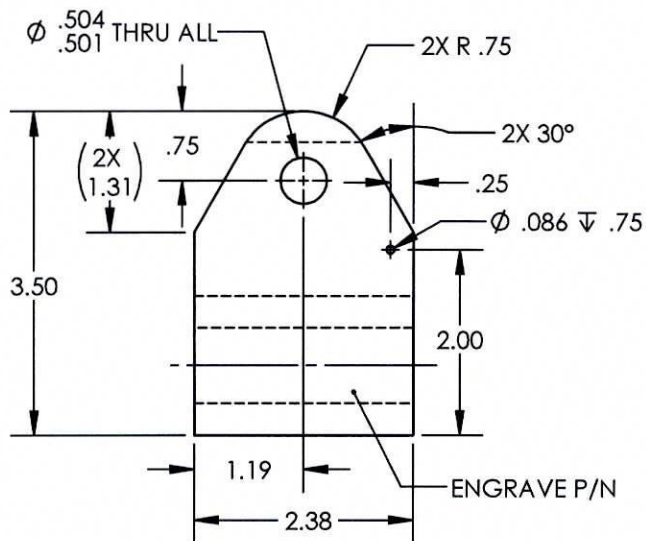
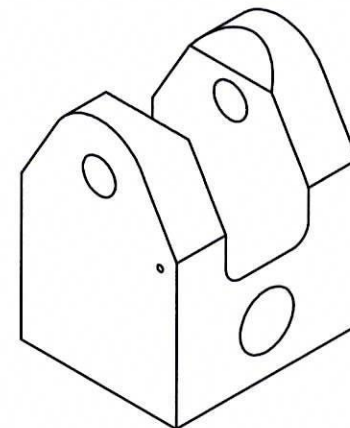
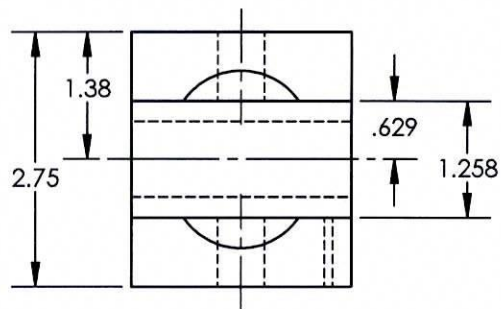
(-107)

SLEEVE

DART AEROSPACE	
TITLE LIFTING TOOL	
DWG NO. RB T102137-111-107	REV A
MAT'L 4130	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J. Gilbert</i>
.XXX ± .005 FRACTIONS ± 1/8	MAT RC 32-37
.XX ± .01 ANGLES ± 5°	TREAT CAD PLATE YELLOW
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 429
SCALE 1:1	DATE 10/1/2014 SHEET 4 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



-113

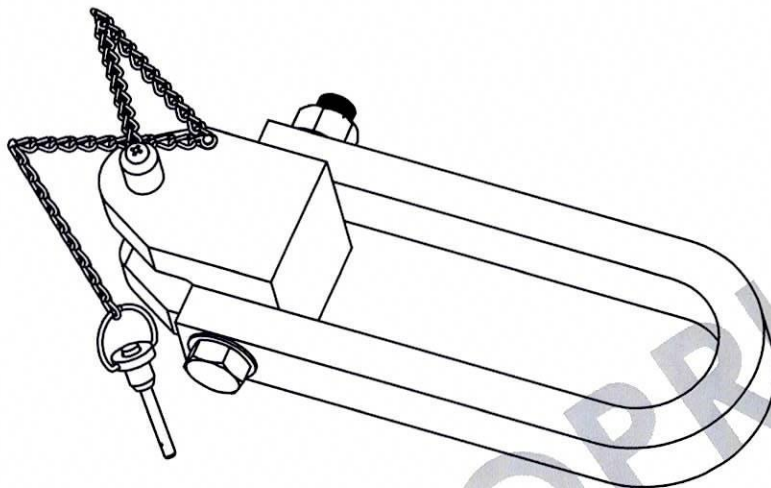
CLEVIS

DART AEROSPACE	
TITLE LIFTING TOOL	
DWG NO. RB T102137-111-113	REV A
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Gilbert</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT RC 32-38
.XX ± .01 ANGLES ± 5°	TREAT CAD PLATE YELLOW
.X ± .1	FINISH QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 429
SCALE 1:2	DATE 10/1/2014
SHEET 5 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

FIRST ARTICLE WEIGHT TEST



INSPECTION & TESTING PROCEDURES FOR THE RB T102137-111 LIFT TOOL. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE.
REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE LIFTING TOOL IN AN APPROPRIATE FIXTURE USE BALL LOCK PIN TO LOCK INTO FIXTURE.
2. APPLY 24,000 lbs. , FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR _____

TESTER _____

S.N. _____

DATE _____



190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE LIFTING TOOL			
DWG NO. RB T102137-111	REV A	CUSTOMER 1 OF 1	
SCALE 1:2	DATE 10/1/2014	SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039773

Supplier: AIH001-VU
Aircraft Hardware and Accessories
P.O. Box 14007
Ft Worth, TX 76617 USA

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039773

PO Date: 5/2/18

Due Date: 5/8/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAY 02 2018

Items										
Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RB T102137-111P		Lifting Tool As Per Dwg RB T102137-111 Rev. A	Firmed	5/8/18	2 pcs	0 pcs	2 pcs	\$2,500.00/pcs	\$5,000.00
Line Item Note w/o 176839										
2	RB T101992P		Nut Scissors Sleeve & Wrench Assembly Sleeve	Firmed	6/5/18	2 Ea	0 Ea	2 Ea	\$530.00/Ea	\$1,060.00
Line Item Note W/O 176828										
Grand Total:										\$6,060.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 PUBLIC LAW 101-592 FASTENER QUALITY ACT
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/2/18 11:07 AM dart.lavoie.chantal

AIRCRAFT HARDWARE & ACCES.
P.O. BOX 14007 FT. WORTH TX 76117
Phone: 817-680-3523 FAX- 817-416-5274
e-mail: sales@aircrafthardwareaccess.com

Packing Slip

ATTN: Shipping Dept.

Date: 5/3/2018

TO: DART AEROSPACE

1270 ABERDEEN STREET
Hawkesbury ON K6A1K7

Packer # 50318

Cust. PO #: 39773

Qty	Tool #	REF#	Description
2	RBT102137-111		LIFTING TOOL



ALL MATERIALS, PARTS OR COMPONENTS HAVE BEEN INSPECTED
AND COMPLY WITH THE PURCHASE ORDER REQUIREMENTS